



## User Manual

Read and understand this manual before using machine.

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# 26" DUAL DRUM SANDER

Model No.  
55220



STEEL CITY TOOL WORKS

Manual Part No. OR71140



**THANK YOU** for purchasing your new Steel City Dual Drum Sander. This drum sander has been designed, tested, and inspected with you, the customer, in mind. When properly used and maintained, your drum sander will provide you with years of trouble free service, which is why it is backed by one of the longest machinery warranties in the business.

This drum sander is just one of many products in the Steel City's family of woodworking machinery and is proof of our commitment to total customer satisfaction.

At Steel City we continue to strive for excellence each and every day and value the opinion of you, our customer. For comments about your drum sander or Steel City Tool Works, please visit our web site at **[www.steelcitytoolworks.com](http://www.steelcitytoolworks.com)** .

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## INTRODUCTION

This user manual is intended for use by anyone working with this machine. It should be kept available for immediate reference so that all operations can be performed with maximum efficiency and safety. Do not attempt to perform maintenance or operate this machine until you have read and understand the information contained in this manual.

The drawings, illustrations, photographs, and specifications in this user manual represent your machine at time of print. However, changes may be made to your machine or this manual at any time with no obligation to Steel City Tool Works.

# **WARRANTY**

## **STEEL CITY TOOL WORKS 5 YEAR LIMITED WARRANTY**

Steel City Tool Works, LLC (“SCTW”) warrants all “STEEL CITY TOOL WORKS” machinery to be free of defects in workmanship and materials for a period of 5 years from the date of the original retail purchase by the original owner. SCTW will repair or replace, at its expense and at its option, any SCTW machine, machine part, or machine accessory which in normal use has proven to be defective, provided that the customer returns the product, shipping prepaid, to an authorized service center with proof of purchase and provides SCTW with a reasonable opportunity to verify the alleged defect by inspection. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, or lack of maintenance, or to repairs or alterations made or specifically authorized by anyone other than SCTW. Normal wear components are also excluded under this coverage. Every effort has been made to ensure that all SCTW machinery meets the highest quality and durability standards. We reserve the right to change specifications at any time due to our commitment to continuous improvement of the quality of our products.

EXCEPT AS SET FORTH ABOVE, SCTW MAKES NO EXPRESS OR IMPLIED REPRESENTATIONS OR WARRANTIES WITH RESPECT TO ITS MACHINERY, OR ITS CONDITION, MERCHANTABILITY, OR FITNESS FOR ANY PARTICULAR PURPOSE OR USE. SCTW FURNISHES THE ABOVE WARRANTIES IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, WHICH ARE HEREBY SPECIFICALLY DISCLAIMED.

SCTW SHALL NOT BE LIABLE FOR ANY (A) SPECIAL, INDIRECT, INCIDENTAL, PUNITIVE OR CONSEQUENTIAL DAMAGES, INCLUDING WITHOUT LIMITATION LOSS OF PROFITS, ARISING FROM OR RELATED TO THIS WARRANTY, THE BREACH OF ANY AGREEMENT OR WARRANTY, OR THE OPERATION OR USE OF ITS MACHINERY, INCLUDING WITHOUT LIMITATION DAMAGES ARISING FROM DAMAGE TO FIXTURES, TOOLS, EQUIPMENT, PARTS OR MATERIALS, DIRECT OR INDIRECT LOSS CAUSED BY ANY OTHER PARTY, LOSS OF REVENUE OR PROFITS, FINANCING OR INTEREST CHARGES, AND CLAIMS BY ANY THIRD PERSON, WHETHER OR NOT NOTICE OF SUCH POSSIBLE DAMAGES HAS BEEN GIVEN TO SCTW; (B) DAMAGES OF ANY KIND FOR ANY DELAY BY OR FAILURE OF SCTW TO PERFORM ITS OBLIGATIONS UNDER THIS AGREEMENT; OR (C) CLAIMS MADE A SUBJECT OF A LEGAL PROCEEDING AGAINST SCTW MORE THAN ONE (1) YEAR AFTER SUCH CAUSE OF ACTION FIRST AROSE.

The validity, construction and performance of this Warranty and any sale of machinery by SCTW shall be governed by the laws of the Commonwealth of Pennsylvania, without regard to conflicts of laws provisions of any jurisdiction. Any action related in any way to any alleged or actual offer, acceptance or sale by SCTW, or any claim related to the performance of any agreement including without limitation this Warranty, shall take place in the federal or state courts in Allegheny County, Pennsylvania.

**STEEL CITY TOOL WORKS**

# WARRANTY CARD

Name \_\_\_\_\_  
 Street \_\_\_\_\_  
 Apt. No. \_\_\_\_\_  
 City \_\_\_\_\_ State \_\_\_\_\_ Zip \_\_\_\_\_  
 Phone Number \_\_\_\_\_  
 E-Mail \_\_\_\_\_

Product Description: \_\_\_\_\_  
 Model No.: \_\_\_\_\_  
 Serial No. \_\_\_\_\_

***The following information is given on a voluntary basis  
 and is strictly confidential.***

1. Where did you purchase your STEEL CITY machine?  
 Store: \_\_\_\_\_  
 City: \_\_\_\_\_

2. How did you first learn of Steel City Tool Works?  
 \_\_\_\_\_ Advertisement \_\_\_\_\_ Mail Order Catalog  
 \_\_\_\_\_ Web Site \_\_\_\_\_ Friend  
 \_\_\_\_\_ Local Store \_\_\_\_\_ Other \_\_\_\_\_

3. Which of the following magazines do you subscribe to?  
 \_\_\_\_\_ American Woodworker \_\_\_\_\_ American How-To  
 \_\_\_\_\_ Cabinetmaker \_\_\_\_\_ Family Handyman  
 \_\_\_\_\_ Fine Homebuilding \_\_\_\_\_ Fine Woodworking  
 \_\_\_\_\_ Journal of Light Construction \_\_\_\_\_ Old House Journal  
 \_\_\_\_\_ Popular Mechanics \_\_\_\_\_ Popular Science  
 \_\_\_\_\_ Popular Woodworking \_\_\_\_\_ Today's Homeowner  
 \_\_\_\_\_ WOOD \_\_\_\_\_ Woodcraft  
 \_\_\_\_\_ WOODEN Boat \_\_\_\_\_ Woodshop News  
 \_\_\_\_\_ Woodsmith \_\_\_\_\_ Woodwork  
 \_\_\_\_\_ Woodworker \_\_\_\_\_ Woodworker's Journal  
 \_\_\_\_\_ Workbench \_\_\_\_\_ Other \_\_\_\_\_

4. Which of the following woodworking / remodeling shows do  
 you watch?  
 \_\_\_\_\_ Backyard America \_\_\_\_\_ The American Woodworker  
 \_\_\_\_\_ Home Time \_\_\_\_\_ The New Yankee Workshop  
 \_\_\_\_\_ This Old House \_\_\_\_\_ Woodwright's Shop  
 Other \_\_\_\_\_

5. What is your annual household income?  
 \_\_\_\_\_ \$20,000 to \$29,999 \_\_\_\_\_ \$30,000 to \$39,999  
 \_\_\_\_\_ \$40,000 to \$49,999 \_\_\_\_\_ \$50,000 to \$59,999  
 \_\_\_\_\_ \$60,000 to \$69,999 \_\_\_\_\_ 70,000 to \$79,999  
 \_\_\_\_\_ \$80,000 to \$89,999 \_\_\_\_\_ \$90,000 +

6. What is your age group?  
 \_\_\_\_\_ 20 to 29 years \_\_\_\_\_ 30 to 39 years  
 \_\_\_\_\_ 40 to 49 years \_\_\_\_\_ 50 to 59 years  
 \_\_\_\_\_ 60 to 69 years \_\_\_\_\_ 70 + years

7. How long have you been a woodworker?  
 \_\_\_\_\_ 0 to 2 years \_\_\_\_\_ 2 to 8 years  
 \_\_\_\_\_ 8 to 20 years \_\_\_\_\_ over 20 years

8. How would you rank your woodworking skills?  
 \_\_\_\_\_ Simple \_\_\_\_\_ Intermediate  
 \_\_\_\_\_ Advance \_\_\_\_\_ Master Craftsman

9. How many Steel City machines do you own? \_\_\_\_\_

10. What stationary woodworking tools do you own?  
*Check all that apply.*  
 \_\_\_\_\_ Air Compressor \_\_\_\_\_ Band Saw  
 \_\_\_\_\_ Drill Press \_\_\_\_\_ Drum Sander  
 \_\_\_\_\_ Dust Collection \_\_\_\_\_ Horizontal Boring Machine  
 \_\_\_\_\_ Jointer \_\_\_\_\_ Lathe  
 \_\_\_\_\_ Mortiser \_\_\_\_\_ Panel Saw  
 \_\_\_\_\_ Planer \_\_\_\_\_ Power Feeder  
 \_\_\_\_\_ Radial Arm Saw \_\_\_\_\_ Shaper  
 \_\_\_\_\_ Spindle Sander \_\_\_\_\_ Table Saw  
 \_\_\_\_\_ Vacuum Veneer Press \_\_\_\_\_ Wide Belt Sander  
 Other \_\_\_\_\_

11. Which benchtop tools do you own? *Check all that apply.*  
 \_\_\_\_\_ Belt Sander \_\_\_\_\_ Belt / Disc Sander  
 \_\_\_\_\_ Drill Press \_\_\_\_\_ Band Saw  
 \_\_\_\_\_ Grinder \_\_\_\_\_ Mini Jointer  
 \_\_\_\_\_ Mini Lathe \_\_\_\_\_ Scroll Saw  
 \_\_\_\_\_ Spindle / Belt Sander \_\_\_\_\_ Other \_\_\_\_\_

12. Which portable / hand held power tools do you own?  
*Check all that apply.*  
 \_\_\_\_\_ Belt Sander \_\_\_\_\_ Biscuit Jointer  
 \_\_\_\_\_ Dust Collector \_\_\_\_\_ Circular Saw  
 \_\_\_\_\_ Detail Sander \_\_\_\_\_ Drill / Driver  
 \_\_\_\_\_ Miter Saw \_\_\_\_\_ Orbital Sander  
 \_\_\_\_\_ Palm Sander \_\_\_\_\_ Portable Thickness Planer  
 \_\_\_\_\_ Saber Saw \_\_\_\_\_ Reciprocating Saw  
 \_\_\_\_\_ Router \_\_\_\_\_ Other \_\_\_\_\_

13. What machines / accessories would you like to see added to the  
 STEEL CITY line?  
 \_\_\_\_\_  
 \_\_\_\_\_

14. What new accessories would you like to see added?  
 \_\_\_\_\_  
 \_\_\_\_\_

15. Do you think your purchase represents good value?  
 \_\_\_\_\_ Yes \_\_\_\_\_ No

16. Would you recommend STEEL CITY products to a friend?  
 \_\_\_\_\_ Yes \_\_\_\_\_ No

17. Comments:  
 \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_

FOLD ON DOTTED LINE

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PLACE  
STAMP  
HERE

**Steel City Tool Works**  
**P.O. Box 10529**  
**Murfreesboro, TN 37129**

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FOLD ON DOTTED LINE

## PRODUCT SPECIFICATIONS

### Drum Motor Specifications

Type	Induction, Ball Bearing
Continuous Duty Horsepower	3HP
Amps	16
Voltage	230V
Phase	single
Hertz	60
RPM	3450(no load)

### Product Dimensions

Footprint	17-3/4" x 43"
Length	31"
Width	46"
Height	53"
Weight	485 lbs.

### Belt Feed Motor Specifications

Type	Universal
Horsepower	1/6 HP

### Shipping Dimensions

Carton Type	wooden crate on skid
Length	33"
Width	48"
Height	55"
Gross Weight	535 lbs.

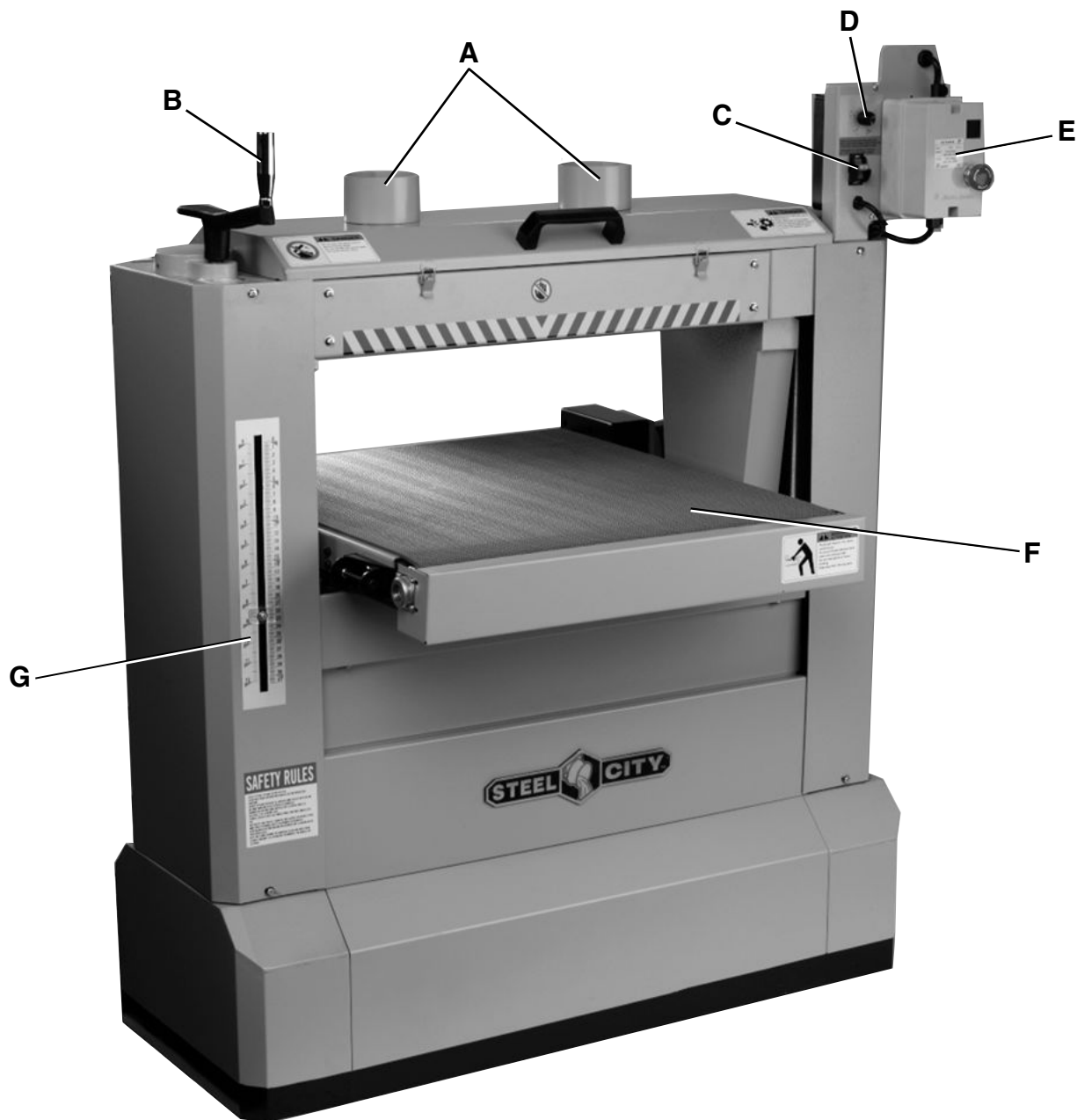
### Product Specifications

Maximum width of sanding	25-1/2"
Maximum thickness of board	12-1/4"
Minimum thickness of board	1/4"
Minimum board length	6"
Feeding Speed	3-20 S.F.P.M. (variable)
Number of Sanding Drums	2
Drum Size	5" x 26"
Drum Speed	1550 R.P.M.
Dust Ports	2 @ 4"

## ACCESSORIES AND ATTACHMENTS

There are a variety of accessories available for your Steel City Product. For more information on any accessories associated with this and other machines, please contact your nearest Steel City distributor, or visit our website at: [www.steelcitytoolworks.com](http://www.steelcitytoolworks.com).

## FEATURE IDENTIFICATION



- A) Dust Ports
- B) Table Elevation Handle Assembly
- C) Conveyor Belt On/Off Switch
- D) Conveyor Belt Variable Speed Control
- E) Sanding Drum On/Off Switch
- F) Conveyor Belt
- G) Depth Gauge



# GENERAL SAFETY

## WARNING

**TO AVOID** serious injury and damage to the machine, read and follow all Safety and Operating Instructions before assembling and operating this machine.

This manual is not totally comprehensive. It does not and can not convey every possible safety and operational problem which may arise while using this machine. The manual will cover many of the basic and specific safety procedures needed in an industrial environment.

All federal and state laws and any regulations having jurisdiction covering the safety requirements for use of this machine take precedence over the statements in this manual. Users of this machine must adhere to all such regulations.

Below is a list of symbols that are used to attract your attention to possible dangerous conditions.



This is the safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.

## DANGER

Indicates an imminently hazardous situation which, if not avoided, **WILL** result in death or serious injury.

## WARNING

Indicates a potentially hazardous situation which, if not avoided, **COULD** result in death or serious injury.

## CAUTION

Indicates a potentially hazardous situation, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

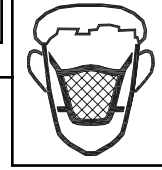
## CAUTION

**CAUTION** used without the safety alert symbol indicates a potentially hazardous situation which, if not avoided, may result in property damage.

## NOTICE

This symbol is used to alert the user to useful information about proper operation of the machine.

## WARNING



Exposure to the dust created by power sanding, sawing, grinding, drilling and other construction activities may cause serious and permanent respiratory or other injury, including silicosis (a serious lung disease), cancer, and death. Avoid breathing the dust, and avoid prolonged contact with dust. The dust may contain chemicals known to the State of California to cause cancer, birth defects or other reproductive harm.

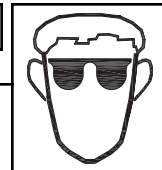
Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks, cement and other masonry products.
- Arsenic and chromium from chemically-treated lumber.

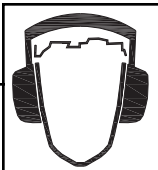
Always operate tool in well ventilated area and provide for proper dust removal. Use a dust collection system along with an air filtration system whenever possible. Always use properly fitting NIOSH/OSHA approved respiratory protection appropriate for the dust exposure, and wash exposed areas with soap and water.

1. To avoid serious injury and damage to the machine, read the entire User Manual before assembly and operation of this machine.

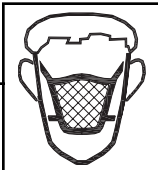
## WARNING



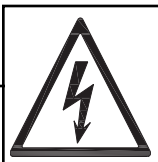
2. **ALWAYS** wear eye protection. Any machine can throw debris into the eyes during operations, which could cause severe and permanent eye damage. Everyday eyeglasses are **NOT** safety glasses. **ALWAYS** wear Safety Goggles (that comply with ANSI standard Z87.1) when operating power tools.

**⚠ WARNING**

3. **ALWAYS** wear hearing protection. Plain cotton is not an acceptable protective device. Hearing equipment should comply with ANSI S3.19 Standards.

**⚠ WARNING**

4. **ALWAYS** wear a NIOSH/OSHA approved dust mask to prevent inhaling dangerous dust or airborne particles.
5. **ALWAYS** keep the work area clean, well lit, and organized. **DO NOT** work in an area that has slippery floor surfaces from debris, grease, and wax.
6. **ALWAYS** unplug the machine from the electrical receptacle when making adjustments, changing parts or performing any maintenance.
7. **AVOID ACCIDENTAL STARTING.** Make sure that the power switch is in the "OFF" position before plugging in the power cord to the electrical receptacle.

**⚠ WARNING**

8. **AVOID** a dangerous working environment. **DO NOT** use electrical tools in a damp environment or expose them to rain or moisture.

**⚠ WARNING**

9. **CHILDPROOF THE WORKSHOP AREA** by removing switch keys, unplugging tools from the electrical receptacles, and using padlocks.
10. **DO NOT** use electrical tools in the presence of flammable liquids or gasses.

11. **DO NOT FORCE** the machine to perform an operation for which it was not designed. It will do a safer and higher quality job by only performing operations for which the machine was intended.
12. **DO NOT** stand on a machine. Serious injury could result if it tips over or you accidentally contact any moving part.
13. **DO NOT** store anything above or near the machine.
14. **DO NOT** operate any machine or tool if under the influence of drugs, alcohol, or medication.
15. **EACH AND EVERY** time, check for damaged parts prior to using any machine. Carefully check all guards to see that they operate properly, are not damaged, and perform their intended functions. Check for alignment, binding or breakage of all moving parts. Any guard or other part that is damaged should be immediately repaired or replaced.
16. Ground all machines. If any machine is supplied with a 3-prong plug, it must be plugged into a 3-contact electrical receptacle. The third prong is used to ground the tool and provide protection against accidental electric shock. **DO NOT** remove the third prong.
17. Keep visitors and children away from any machine. **DO NOT** permit people to be in the immediate work area, especially when the machine is operating.
18. **KEEP** protective guards in place and in working order.
19. **MAINTAIN** your balance. **DO NOT** extend yourself over the tool. Wear oil resistant rubber soled shoes. Keep floor clear of debris, grease, and wax.
20. **MAINTAIN** all machines with care. **ALWAYS KEEP** machine clean and in good working order. **KEEP** all blades and tool bits sharp.
21. **NEVER** leave a machine running, unattended. Turn the power switch to the OFF position. **DO NOT** leave the machine until it has come to a complete stop.
22. **REMOVE ALL MAINTENANCE TOOLS** from the immediate area prior to turning the machine ON.
23. **SECURE** all work. When it is possible, use clamps or jigs to secure the workpiece. This is safer than attempting to hold the workpiece with your hands.
24. **STAY ALERT**, watch what you are doing, and use common sense when operating any machine. **DO NOT** operate any machine tool while tired or under the influence of drugs, alcohol, or medication. A moment of inattention while operating power tools may result in serious personal injury.

25. **USE ONLY** recommended accessories. Use of incorrect or improper accessories could cause serious injury to the operator and cause damage to the machine. If in doubt, **DO NOT** use it.
26. **THE USE** of extension cords is not recommended for 230V equipment. It is better to arrange the placement of your equipment and the installed wiring to eliminate the need for an extension cord. If an extension cord is necessary, refer to the chart in the Grounding Instructions section to determine the minimum gauge for the extension cord. The extension cord must also contain a ground wire and plug pin.
27. Wear proper clothing, **DO NOT** wear loose clothing, gloves, neckties, or jewelry. These items can get caught in the machine during operations and pull the operator into the moving parts. Users must wear a protective cover on their hair, if the hair is long, to prevent it from contacting any moving parts.
28. **SAVE** these instructions and refer to them frequently and use them to instruct other users.
29. Information regarding the safe and proper operation of this tool is also available from the following sources:

Power Tool Institute  
1300 Summer Avenue  
Cleveland, OH 44115-2851  
[www.powertoolinstitute.org](http://www.powertoolinstitute.org)

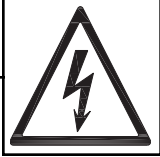
National Safety Council  
1121 Spring Lake Drive  
Itasca, IL 60143-3201

American National Standards Institute  
25 West 43rd Street, 4th floor  
New York, NY 10036  
[www.ansi.org](http://www.ansi.org)


ANSI 01.1 Safety Requirements for  
Woodworking Machines, and the U.S. Department  
of Labor regulations  
[www.osha.gov](http://www.osha.gov)

## PRODUCT SAFETY

1. Serious personal injury may occur if normal safety precautions are overlooked or ignored. Accidents are frequently caused by lack of familiarity or failure to pay attention. Obtain advice from supervisor, instructor, or another qualified individual who is familiar with this machine and its operations.
  2. Every work area is different. Always consider safety first, as it applies to your work area. Use this machine with respect and caution. Failure to do so could result in serious personal injury and damage to the machine.
  3. Prevent electrical shock. Follow all electrical and safety codes, including the National Electrical Code (NEC) and the Occupational Safety and Health Regulations (OSHA). All electrical connections and wiring should be made by qualified personnel only.
- ⚠ WARNING**



4. **TO REDUCE** the risk of electrical shock. **DO NOT** use this machine outdoors. **DO NOT** expose to rain or moisture. Store indoors in a dry area.
5. **STOP** using this machine, if at any time you experience difficulties in performing any operation. Contact your supervisor, instructor or machine service center immediately.
  6. Safety decals are on this machine to warn and direct you to how to protect yourself or visitors from personal injury. These decals **MUST** be maintained so that they are legible. **REPLACE** decals that are not legible.
  7. **DO NOT** leave the unit plugged into the electrical outlet. Unplug the unit from the outlet when not in use and before servicing, performing maintenance tasks, or cleaning.
  8. **ALWAYS** turn the power switch "OFF" before unplugging the drum sander.
- ⚠ WARNING**

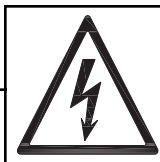


9. **DO NOT** handle the plug or drum sander with wet hands.
10. **USE** accessories only recommended by Steel City.
  11. **DO NOT** pull the drum sander by the power cord. **NEVER** allow the power cord to come in contact with sharp edges, hot surfaces, oil or grease.
  12. **DO NOT** unplug the drum sander by pulling on the power cord. **ALWAYS** grasp the plug, not the cord.
  13. **REPLACE** a damaged cord immediately. **DO NOT** use a damaged cord or plug. If the drum sander is not operating properly, or has been damaged, left outdoors or has been in contact with water.
  14. **DO NOT** use the drum sander as a toy. **DO NOT** use near or around children.

15. **ALWAYS** wear eye protection. The operation of any drum sander can result in debris being thrown into your eyes, causing severe eye damage. Everyday glasses are not safety glasses. Wear safety glasses that comply with ANSI standard Z87.1
16. **KEEP** hands and clothing away from the rotating drum, belts and pulleys. **NEVER** place hands under the drum or dust cover.
17. **ALWAYS** feed workpieces against the rotation of the drum.
18. **HOLD** workpieces firmly and be aware of the possibility of kickback.
19. **DO NOT** make passes deeper than recommended in the specifications to avoid damage to the machine.
20. **NEVER** operate the machine without the dust cover and belt guard in position.
21. **ALWAYS** stand to one side of the workpiece; **NEVER** stand directly in line with it.
22. **NEVER** force the workpiece into the sander; allow the feed belt to move the workpiece at the proper speed.
23. **MAKE SURE** that the workpiece has no loose knots, screws, nails or other foreign objects that might damage the feed belt or sanding drum.
24. **ALWAYS** keep bystanders and yourself away from the infeed and outfeed ends when a workpiece is fed into the sander.
25. **ALWAYS** keep your hands away from the sanding drums during operation.
26. **ALWAYS** keep fingers away from the conveyor and the underside of the workpiece during sander and conveyor operation.
27. **ALWAYS** adjust the conveyor feed rate and sanding drum height, so when you feed the workpiece into the sander using light pressure, you do not overload the sander. **NEVER** force the workpiece into the sander.
28. **ALWAYS** shut the sander down, let the drums come to a complete stop, and disconnect power or engage applicable safety-lock devices before you service, adjust, troubleshoot, or leave the machine unattended.
29. **ALWAYS** keep this machine in correct adjustment and properly serviced. **NEVER** attempt to clear a jammed workpiece while the sander is running.
30. **ALWAYS** replace the sandpaper when it is worn, and use only undamaged sandpaper.
31. **NEVER** sand if there is any doubt about the stability or integrity of the workpiece.
32. **NEVER** sand stock smaller than 1/4" thick or 6" long.
33. **NEVER** adjust the conveyor belt tracking when the sanding drums are engaged.

## ELECTRICAL REQUIREMENTS

### **WARNING**



To reduce the risk of electric shock, follow all electrical and safety codes, including the National Electric Code (NEC) and the Occupational Safety and Health Regulations (OSHA). All electrical connections and wiring should be made by qualified personnel only.

The switch provided with your dual drum sander is designed to plug in to a 230V outlet. Since there are many different configurations for 230V plugs, it is conceivable that the configuration of your 230V outlet may not match the configuration of the plug. If this is the case, you will have to replace the plug with a UL/CSA approved plug that matches the configuration of your 230V outlet.

**DO NOT** connect the machine to the power source until you have completed the setup process.

# GROUNDING INSTRUCTIONS

## ⚠ WARNING



This machine **MUST BE GROUNDED** while in use to protect the operator from electric shock.

In the event of a malfunction or breakdown, **GROUNDING** provides the path of least resistance for electric current and reduces the risk of electric shock. The plug **MUST** be plugged into a matching electrical receptacle that is properly installed and grounded in accordance with **ALL** local codes and ordinances.

If a plug is provided with your machine **DO NOT** modify the plug. If it will not fit your electrical receptacle, have a qualified electrician install the proper connections to meet all electrical codes local and state. All connections must also adhere to all of OSHA mandates.

**IMPROPER ELECTRICAL CONNECTION** of the equipment-grounding conductor can result in risk of electric shock. The conductor with the green insulation (with or without yellow stripes) is the equipment-grounding conductor. **DO NOT** connect the equipment-grounding conductor to a live terminal if repair or replacement of the electric cord or plug is necessary.

Check with a qualified electrician or service personnel if you do not completely understand the grounding instructions, or if you are not sure the tool is properly grounded.

## PLUGS/RECEPTACLES

## ⚠ WARNING



- Electrocutation or fire could result if this machine is not grounded properly or if the electrical configuration does not comply with local and state electrical codes.
- **MAKE CERTAIN** the machine is disconnected from power source before starting any electrical work.
- **MAKE SURE** the circuit breaker does not exceed the rating of the plug and receptacle.

The motor supplied with your machine is a 230 volt, 60 hertz, single phase motor. Never connect the green or ground wire to a live terminal.

A machine with a 230 volt plug should only be connected to an outlet having the same configuration as the plug.

## EXTENSION CORDS

## ⚠ WARNING



To reduce the risk of fire or electrical shock, use the proper gauge of extension cord. When using an extension cord, be sure to use one heavy enough to carry the current your machine will draw.

The smaller the gauge-number, the larger the diameter of the extension cord is. If in doubt of the proper size of an extension cord, use a shorter and thicker cord. An undersized cord will cause a drop in line voltage resulting in a loss of power and overheating.

## ⚠ WARNING

**USE ONLY** a 3-wire extension cord that has a 3-prong grounding plug and a 3-pole receptacle that accepts the machine's plug.

If you are using an extension cord outdoors, be sure it is marked with the suffix "W-A" ("W" in Canada) to indicate that it is acceptable for outdoor use.

Make certain the extension cord is properly sized, and in good electrical condition. Always replace a worn or damaged extension cord immediately or have it repaired by a qualified person before using it.

Protect your extension cords from sharp objects, excessive heat, and damp or wet areas.

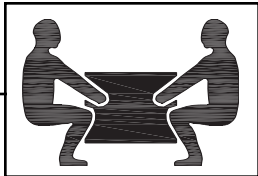
### MINIMUM RECOMMENDED GAUGE FOR EXTENSION CORDS (AWG)

230 VOLT OPERATION ONLY			
	25' LONG	50' LONG	100' LONG
0 to 6 Amps	16 AWG	16 AWG	14 AWG
6 to 8 Amps	16 AWG	16 AWG	12 AWG
8 to 12 Amps	14 AWG	14 AWG	10 AWG
12 to 15 Amps	12 AWG	12 AWG	10 AWG
15 to 20 Amps	10 AWG	10 AWG	Not recommended



# UNPACKING & INVENTORY

## ⚠ WARNING



- The machine is heavy, two people are required to unpack and lift.
- Use a safety strap to avoid tip over when lifting machine.

Check shipping carton and machine for damage before unpacking. Carefully remove packaging materials, parts and machine from shipping carton. Always check for and remove protective shipping materials around motors and moving parts. Lay out all parts on a clean work surface.

Remove any protective materials and coatings from all of the parts and the drum sander. The protective coat-

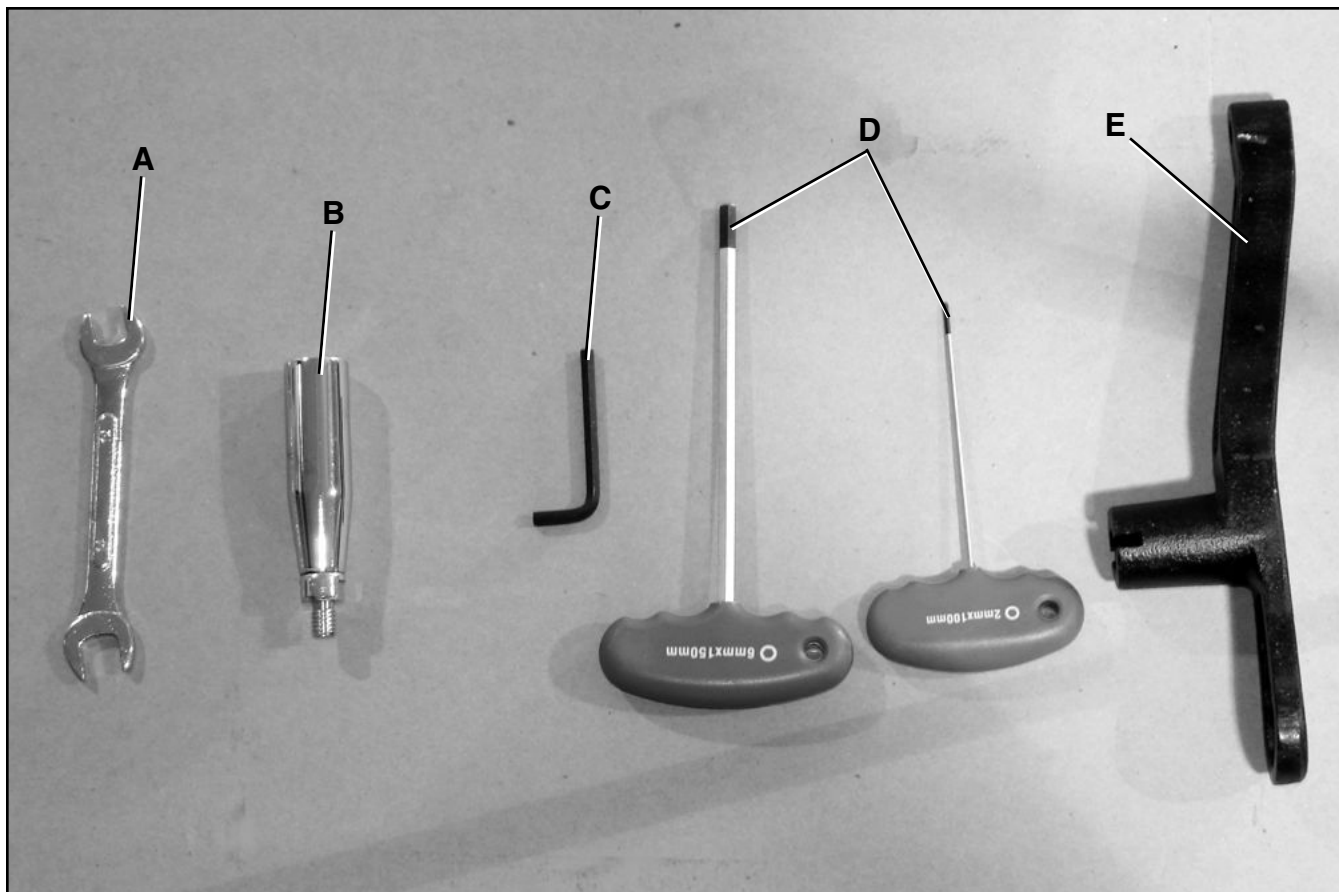
ings can be removed by spraying WD-40 on them and wiping it off with a soft cloth. This may need redone several times before all of the protective coatings are removed completely.

After cleaning, apply a good quality paste wax to any unpainted surfaces. Make sure to buff out the wax before assembly.

Compare the items to inventory figures; verify that all items are accounted for before discarding the shipping box.

## ⚠ WARNING

If any parts are missing, do not attempt to plug in the power cord and turn "ON" the machine. The machine should only be turned "ON" after all the parts have been obtained and installed correctly. **For missing parts, contact Steel City at 1-877-SC4-TOOL.**



- A) Open End Wrench
- B) Elevation Handle
- C) Hex Wrench
- D) T Handle Wrenches
- E) Elevation Bracket

# ASSEMBLY

## TRANSPORT

Transport the machine to the required work area with the use of a forklift or a lifting hook. The equipment used for the transportation must be of adequate capacity to move the sander.

1. Install the table elevation crank (A) as illustrated. The slots on the shaft and crank handle must be aligned. Fasten the crank handle to the shaft with the pin supplied. **SEE FIG. 1.**

**Fig. 1**



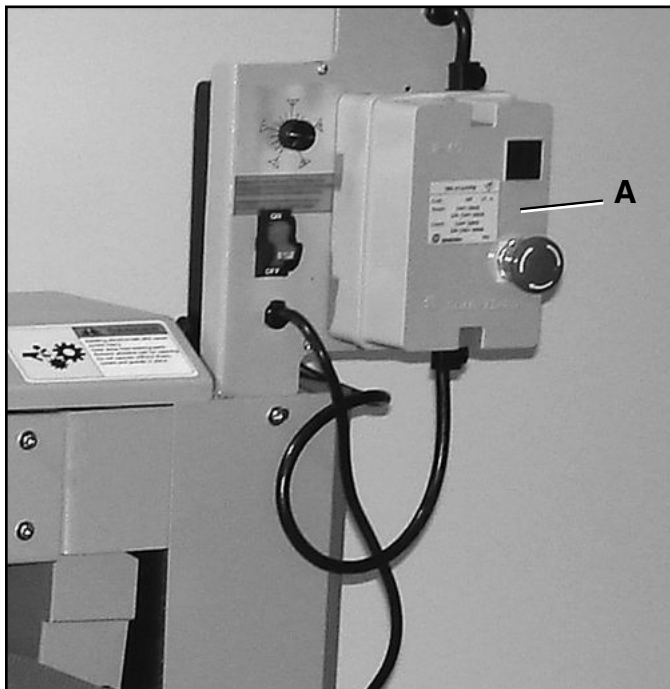
## MOUNTING SWITCH

Mount switch assembly (A) using two 10mm bolts (B) as pictured on upper right side of machine. **SEE FIGS. 2 AND 3.**

**Fig. 2**



**Fig. 3**



## DUST COLLECTOR CONNECTION

The 26" horizontal drum sander is equipped with two 4" dust chutes. Ring clamps must be used to connect the dust collection hoses to the chutes.

### **⚠ WARNING**

**NEVER ATTEMPT TO OPERATE YOUR MACHINE WITHOUT A DUST COLLECTOR ATTACHED AND RUNNING!**

## MOUNTING AND REPLACING SANDING BELTS

### **⚠ WARNING**

**MAKE CERTAIN THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE BEFORE MOUNTING THE SANDING BELT!**

## REMOVING THE SANDING BELTS

In order to access the sanding drums, lift and tilt the upper guard towards the rear. The sanding belts are fixed at either end of the drums by spring-loaded clamps.

### TO REMOVE THE SANDING BELTS:

1. Push the right clamp forward; the tab of the sanding belt must be pulled out of the right drum slot.  
**SEE FIG. 4.**

**Fig. 4**



2. Unwind the sanding belt from the drum, and push the clamp forward at the left side of the drum to remove the sanding belt tab from the left drum slot.

## MOUNTING NEW SANDING BELTS

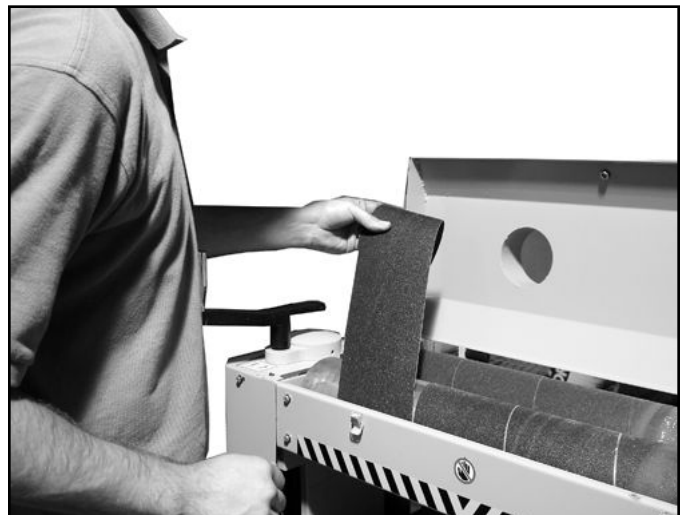
1. Insert tab of the belt on the left end of the drum.  
**SEE FIG. 5.**

**Fig. 5**



2. Push the left clamp forward to allow the tab to slide under the clamp.
3. Release the clamp to lock the belt tab into place.
4. Roll the sanding belt onto the drum, keeping the edges snug. **SEE FIG. 6.**

**Fig. 6**



5. Insert the tab (right end of the sanding belt) into the slot at the other end of the drum.
6. Push the clamp forward so that the tab will slide in.
7. The clamps are spring-loaded and will hold the belt tightly as the drum rotates.
8. Repeat Steps 1 through 7 for the remaining drum.

The rear sanding drums should be fitted with a finer sanding paper than the front drum, allowing for coarse and fine sanding to be achieved with one pass.



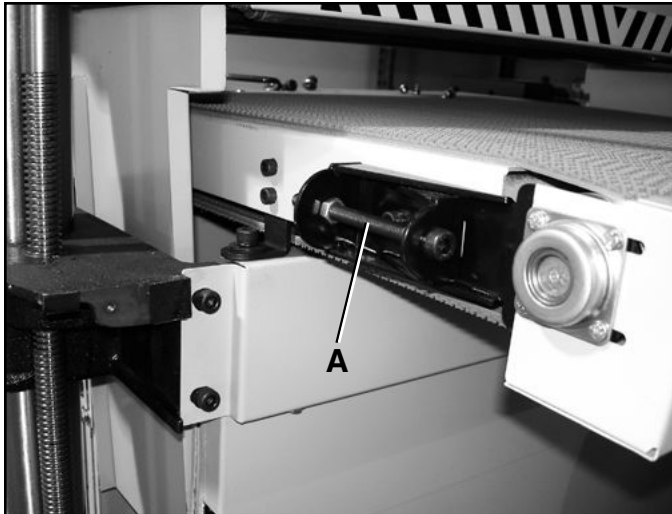
# ADJUSTMENTS

## CONVEYOR BELT TENSION AND TRACKING

The conveyor belt may slide to the right or left during operations if the tension of the conveyor belt is too loose or too tight. To adjust, follow these procedures:

1. While the unit is running, turn the adjustment bolts (A) on either side of the conveyor table. **SEE FIG. 7.**

**Fig. 7**



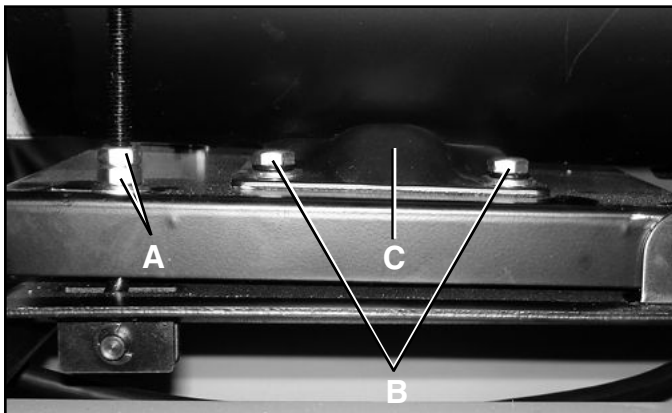
2. The conveyor belt should run at the center of the conveyor table, and should be tensioned so that there is good traction during stock feeding.

## SANDING DRUM DRIVE BELTS

Both sanding drums are driven by two belts and powered by one motor. If the belt becomes too loose, follow these procedures:

1. Remove the right end guard, and the front guard.
2. Adjust the height position of the motor by turning the M12 nuts (A) located on the height adjustment bolt. **SEE FIG. 8.**

**Fig. 8**



3. If the motor becomes damaged and needs to be replaced, remove the bolts (B) on the bottom of the motor base plate (C), and remove the entire motor assembly.

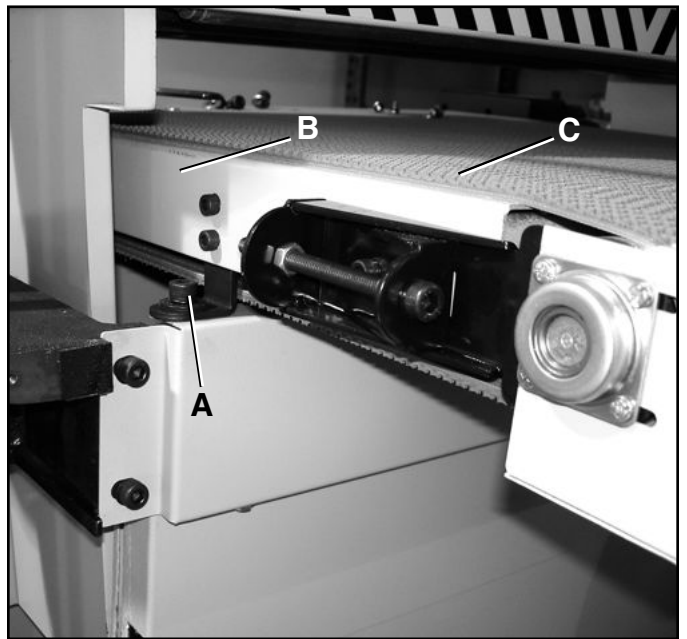
## REPLACING THE CONVEYOR BELT

If the conveyor belt gets too worn out, the material being fed will not produce satisfactory results. The conveyor belt will need to be replaced for ideal results.

### TO REPLACE THE CONVEYOR BELT:

1. Remove the guards at both ends of the sander.
2. The four cap screws (A) at the bottom of the feed table assembly must be removed. **SEE FIG. 9.**

**Fig. 9**



3. You can now remove the feed table (B); this will allow you to replace the conveyor belt (C).

## PARALLELISM ADJUSTMENT OF SANDING DRUM

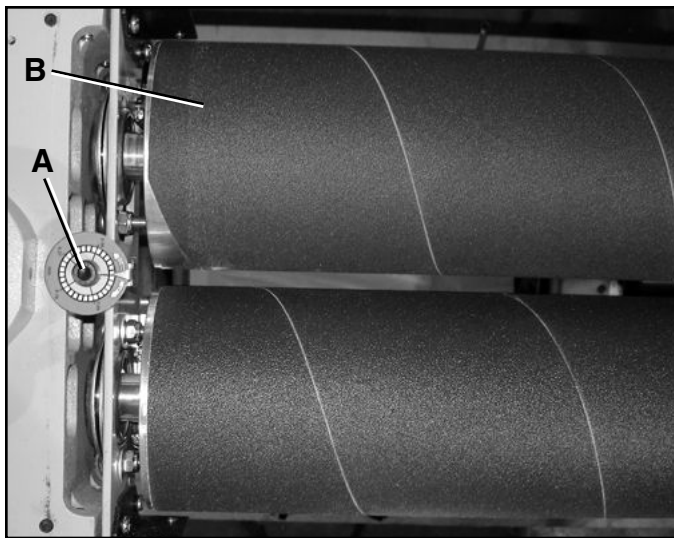
The front sanding drum has been factory adjusted and needs no further adjustment. The rear sanding drum must be adjusted for parallelism.

### TO ADJUST, FOLLOW THESE PROCEDURES:

1. Adjust using the cap screws (A) on either end of the sanding drums (B), using a T-wrench. Turning the cap screw clockwise will raise the drum while turning it counterclockwise will lower the drum.

SEE FIG. 10.

Fig. 10



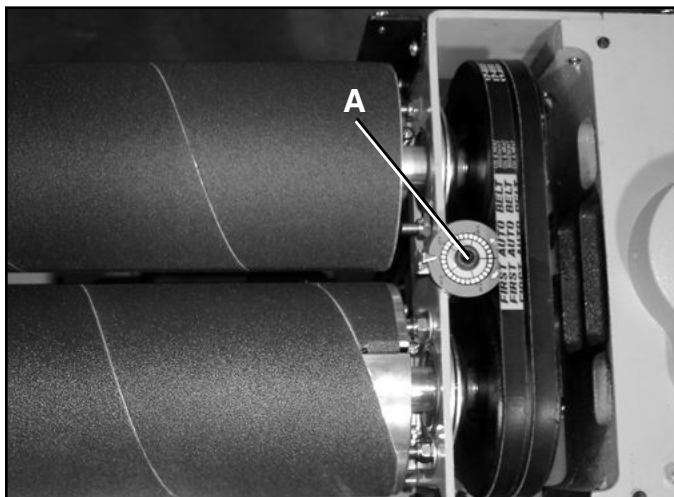
2. Make adjustments to both sides of the rear drum if necessary, until it is parallel with the front drum.

## DRUM HEIGHT

When using different abrasive grits on the drums, the height of the drums from the workpiece must vary. To achieve this, the back drum (which should always have the finer grit) has been designed for easy adjustment.

1. Rotate the cap screw (A) to the desired measurement. SEE FIG. 11.

Fig. 11



2. Repeat this dial setting on the opposite end of the drum. **NOTE:** It is important that the dial setting be identical at both ends of the drum.

**IMPORTANT:** After changing abrasive strips, always check and, if necessary, reset the back drum height.

The chart below shows the proper settings based upon sanding grits.

REAR DRUM SETTING GAUGE	
Front Drum Grit / Rear Drum Grit	Setting (mm)
80/100, 120/150, 120/180, 150/220	.15
80/120, 100/150, 100/180	.30
60/100, 36/38	.40
36/120	.56
36/60	.76
36/80	.93

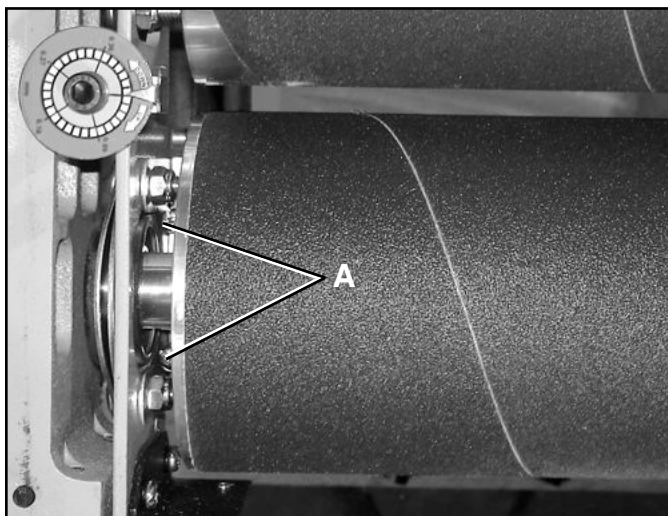
## PRESSURE ROLLERS

The pressure rollers maintain tension upon the workpiece as it passes through the machine. The spring tension of the pressure rollers has been factory set. If a board refuses to pass through the machine, or the finished surface of a board is uneven, the spring tension of the pressure rollers may need adjusting.

1. Turn the Phillips head screws (A), clockwise to increase the roller pressure on the workpiece; or counterclockwise to decrease the pressure.

SEE FIG. 12.

Fig. 12



2. Repeat this same adjustment at the opposite end of the roller to maintain parallel.
3. Repeat procedure for the other pressure roller.

### ⚠ CAUTION

Do not overtighten the adjusting screw, as excess roller pressure will prevent the workpiece from passing through the machine, and may cause the conveyor belt to stop.

# OPERATIONS

## OPERATING TIPS

The basic operating procedure for the Dual Drum Sander is as follows:

1. Set depth of wood removal.
2. Start drums.
3. Start conveyor and select feed rate.
4. Start dust collector system.
5. Feed stock through unit.

Determining depth of cut is one of the most important procedures for the sander. It may take some experimentation to determine the proper depth of cut, given the variables of abrasive grit, type of wood, and feed rate. For best results, use scrap wood to practice sanding and to develop skill and familiarity with the machine before doing finish work.

A good rule of thumb when sanding with grits finer than 80 is to lower the drum so it contacts the workpiece but drum can still be rotated by hand. When using grits coarser than 80 grit, you can lower the drum slightly more. However, a combination of several variables will determine the proper depth of cut to use, including the following:

1. Abrasive type and grit size.
2. Width of the piece being processed.
3. Hardness of the piece.
4. Feed rate of the conveyor belt.

## STOCK FEEDING ANGLE

Some pieces, because of their dimensions, will need to be fed into the machine at a 90-degree angle (perpendicular to the drums). However, even a slight offset angle of the stock will provide for more effective stock removal. The optimum feeding angle is about 60-degrees. Angling the workpiece for stock removal provides other advantages, such as less loading of certain areas of the drums due to glue lines or mineral streaks in the stock, more even wear of abrasive strips, potentially faster feed rates, and lighter loads on the motor.

Note that to get the best final finish, however, the stock should be fed through the machine so it will be sanded in line with the grain of the wood on the final one or two passes.

## MULTIPLE-PIECE SANDING RUNS

When determining sanding thickness, consider cups and crowns that are in the workpiece. When sanding multiple pieces simultaneously, make sure to stagger (step) the pieces across the width of the conveyor belt. This produces better contact with the pressure rollers. Try to only process multiple pieces of similar thickness. If there is a significant thickness difference, the thinner pieces may slip on the conveyor belt if they do not contact the pressure rollers.

## EDGE SANDING

When edge sanding, the sander will mimic the opposite edge of the stock which is lying on the conveyor belt. Because of this, it is important for the stock edge to have been ripped at the proper angle to the face before the sanding process. When edge sanding small stock, clamp several pieces together to prevent them from slipping on the conveyor belt.

## SANDING IMPERFECT STOCK

When sanding stock with a cup or crown, place the crown up. This will stabilize the stock to help prevent tipping or rocking during sanding. (After the crown has been removed and the top is flat, turn the stock over and sand the opposite side.) To avoid personal injury, take special care when sanding stock that is twisted, bowed, or otherwise varies in thickness from end to end.

If possible, support such stock as it is being sanded to keep it from slipping or tipping. Use extra roller stand, help from another person, or hand pressure on the stock to minimize potentially hazardous situations.

## FACE FRAMES AND RAISED PANEL DOORS

It is important to have the proper abrasive contact when doing this type of sanding. If the machine is set to take an excessive depth of cut, the result can be a gouge or dip as the drum goes from sanding the rails at full width to sanding just a few inches of width of the stiles.

## ABRASIVES

The abrasive material you choose will have a substantial effect on the performance of your sander. Variations in paper type, weight, coating and durability all contribute to achieving your desired finish. Ready-To-Cut strips are available from your Steel City Distributor.

As with any sanding operation, first begin sanding with a coarser grit, depending on the roughness of the stock or the amount of stock to be removed. Then progressively work toward finer grits. This means if you are using two different grits on your 55220 dual drum sander, **the coarser grit should always be placed on the front drum.**

The amount of stock to be removed is a major consideration when choosing the grit grade to start with. Grits 36 and 60 are primarily designed for stock removal; grits over 100 are primarily finishing grits designed to remove the scratch pattern from the previous grit used. For best results, never skip more than one grit grade when progressing through a sanding sequence.

For fine work, such as furniture, try not to skip any grit grades during the sanding process. In general, premium quality abrasives will produce a better finish with a less noticeable scratch pattern.

**CAUTION:** Grits that are too fine can sometimes burnish the wood and leave a glossy surface which will not accept stains evenly. This will vary by type of wood. Oak, for example, is susceptible to burnishing because of its open pores.

**Cleaning abrasive strips.** Regularly clean the abrasive strips on the drums with commercially available cleaning sticks, following the manufacturer's directions. When cleaning, also brush the stick crumbs from the drum while it is still rotating.

## CAUTION

**Wear tight fitting clothes and eye protection during this procedure; stay alert to prevent injury.**

Cloth backed abrasives can be cleaned by soaking in paint thinner or mineral spirits for 20 minutes to 1 hour, then using a brush to remove any build-up or burns. Dry the abrasive strips completely before reuse.

**Extending Abrasive Life.** Abrasive life can also be increased by removing the abrasive strip from the drum and reversing it. To do this, remove the strip and use what was the trailing end as the starting end on the right side of the drum. Reversing the strip will provide a fresh set of cutting edges on the abrasive.

## READY-TO-CUT ABRASIVE STRIPS

<u>Description</u>	<u>Normal Use</u>
60 Grit Sandpaper	surfacing and dimensioning boards, trueing warped boards
80 Grit Sandpaper	surfacing, light dimensioning, removing planer ripples
120 Grit Sandpaper	light surfacing, minimal stock removal
150 Grit Sandpaper	finish sanding, minimal stock removal
180 Grit Sandpaper	finish sanding only, not for stock removal
220 Grit Sandpaper	finish sanding only, not for stock removal

## MAINTENANCE

### LUBRICATION AND MAINTENANCE

**NOTE: Disconnect machine from power source before performing any maintenance or lubrication.**

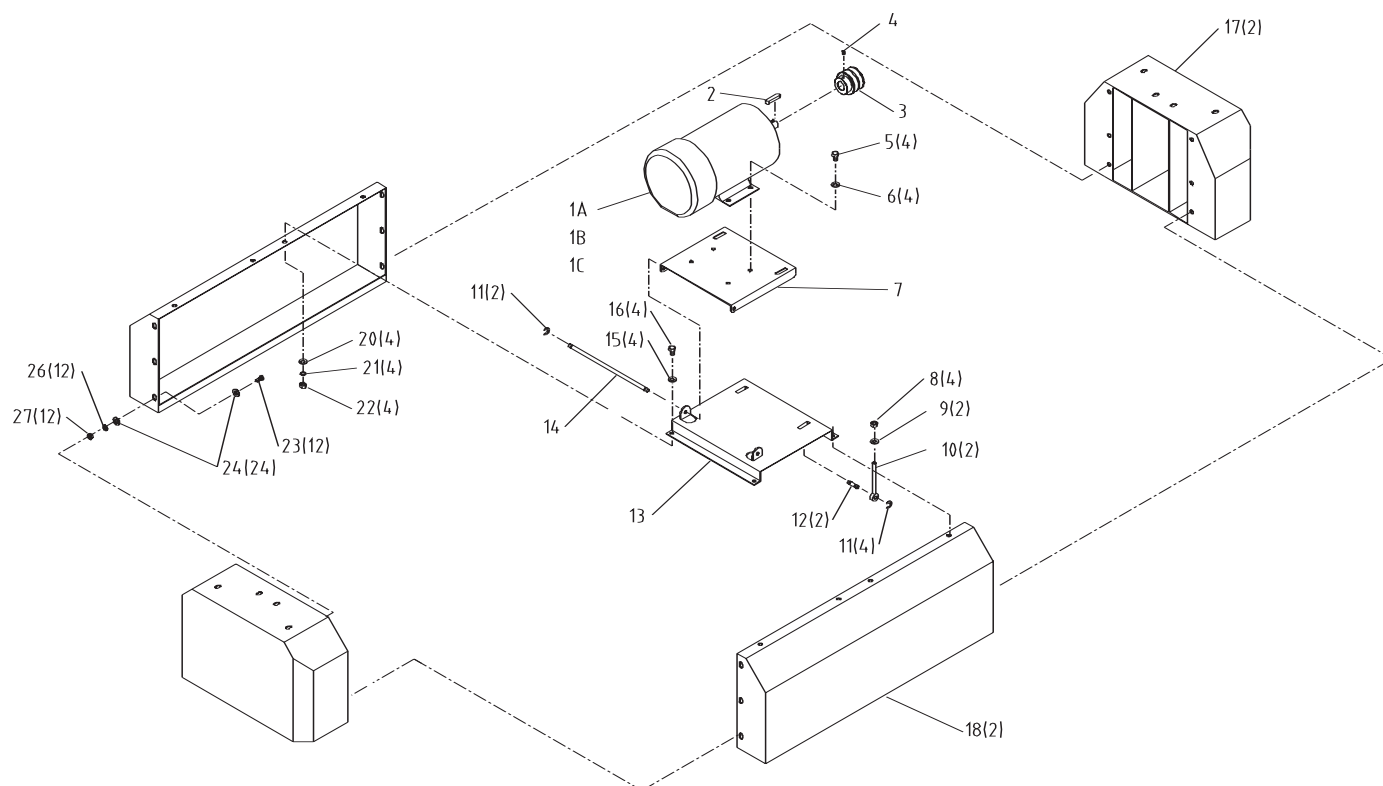
1. The table height adjustment screw shafts, located at either end of the machine must be well lubricated with grease at all times.
2. Verify that all nuts and screws are properly tightened before sanding. Verify that the sanding belts are mounted properly and have not become loose or torn.
3. Remove any dust or particles from machine; never allow dust to accumulate on or in the machine.

# TROUBLESHOOTING GUIDE

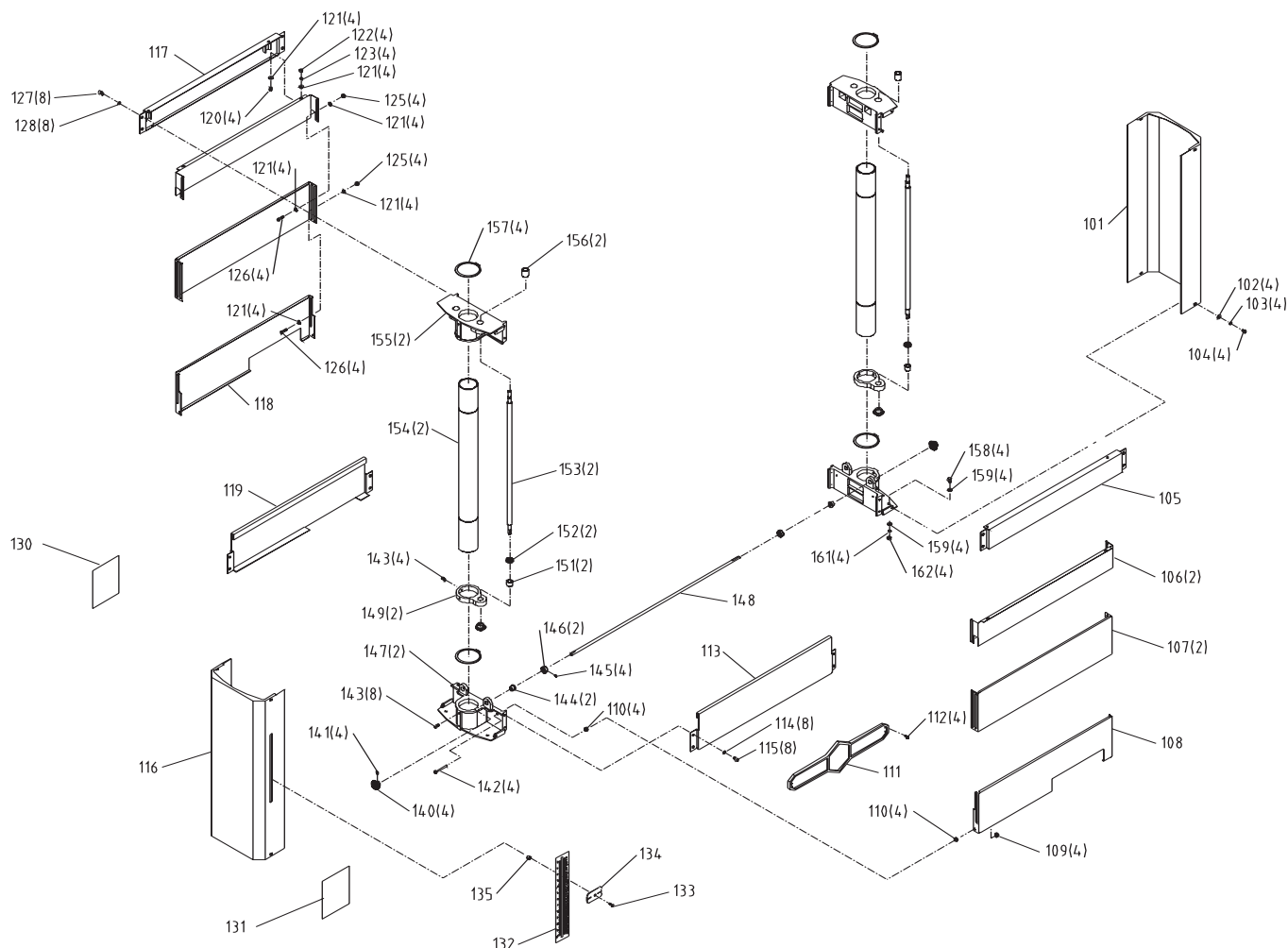
To prevent injury to yourself or damage to the drum sander, turn the switch to the OFF position and unplug the power cord from the electrical receptacle before making any adjustments.

PROBLEM	SOLUTION
<b>Sanding paper clogs too quickly.</b>	<ol style="list-style-type: none"> <li>1. Sanding paper grit too fine.</li> <li>2. Too much material is removed at once.</li> <li>3. Dirty board surface.</li> <li>4. Insufficient dust collection.</li> <li>5. Stock is too oily.</li> <li>6. Board contains too much moisture.</li> <li>7. Sandpaper worn out.</li> </ol>
<b>Sandpaper tearing.</b>	<ol style="list-style-type: none"> <li>1. Drums not perpendicular to feed direction.</li> <li>2. Drums not parallel to conveyor table.</li> <li>3. Sandpaper edges overlapped.</li> <li>4. Tape is slipping.</li> <li>5. Too much material is removed at once.</li> </ol>
<b>Rounding occurs on the edges.</b>	<ol style="list-style-type: none"> <li>1. Too much material is removed at once.</li> </ol>
<b>Uneven thickness on right and left side of the board.</b>	<ol style="list-style-type: none"> <li>1. Drums are not parallel to conveyor table.</li> <li>2. Uneven wear of sanding paper.</li> </ol>
<b>Stock slips on the conveyor belt.</b>	<ol style="list-style-type: none"> <li>1. Too much material is removed at once.</li> <li>2. Too much dust on the conveyor belt surface.</li> <li>3. Worn conveyor belt.</li> </ol>
<b>Shiny spots on sanded surface.</b>	<ol style="list-style-type: none"> <li>1. Sanding paper too old.</li> <li>2. Drums too high.</li> </ol>
<b>Marks on sanded surface.</b>	<ol style="list-style-type: none"> <li>1. Partial damage to sanding paper.</li> <li>2. Paper overlapped on edges.</li> </ol>
<b>Conveyor belt does not run smoothly or stops completely.</b>	<ol style="list-style-type: none"> <li>1. Conveyor belt tension is incorrect.</li> <li>2. Belt tracking is incorrect.</li> </ol>
<b>Consistently noticeable “snipe”</b>	<ol style="list-style-type: none"> <li>1. No outfeed support.</li> <li>2. Pressure roller spring tension incorrect.</li> <li>3. Drum height incorrect in relation to pressure rollers.</li> </ol>

# PARTS

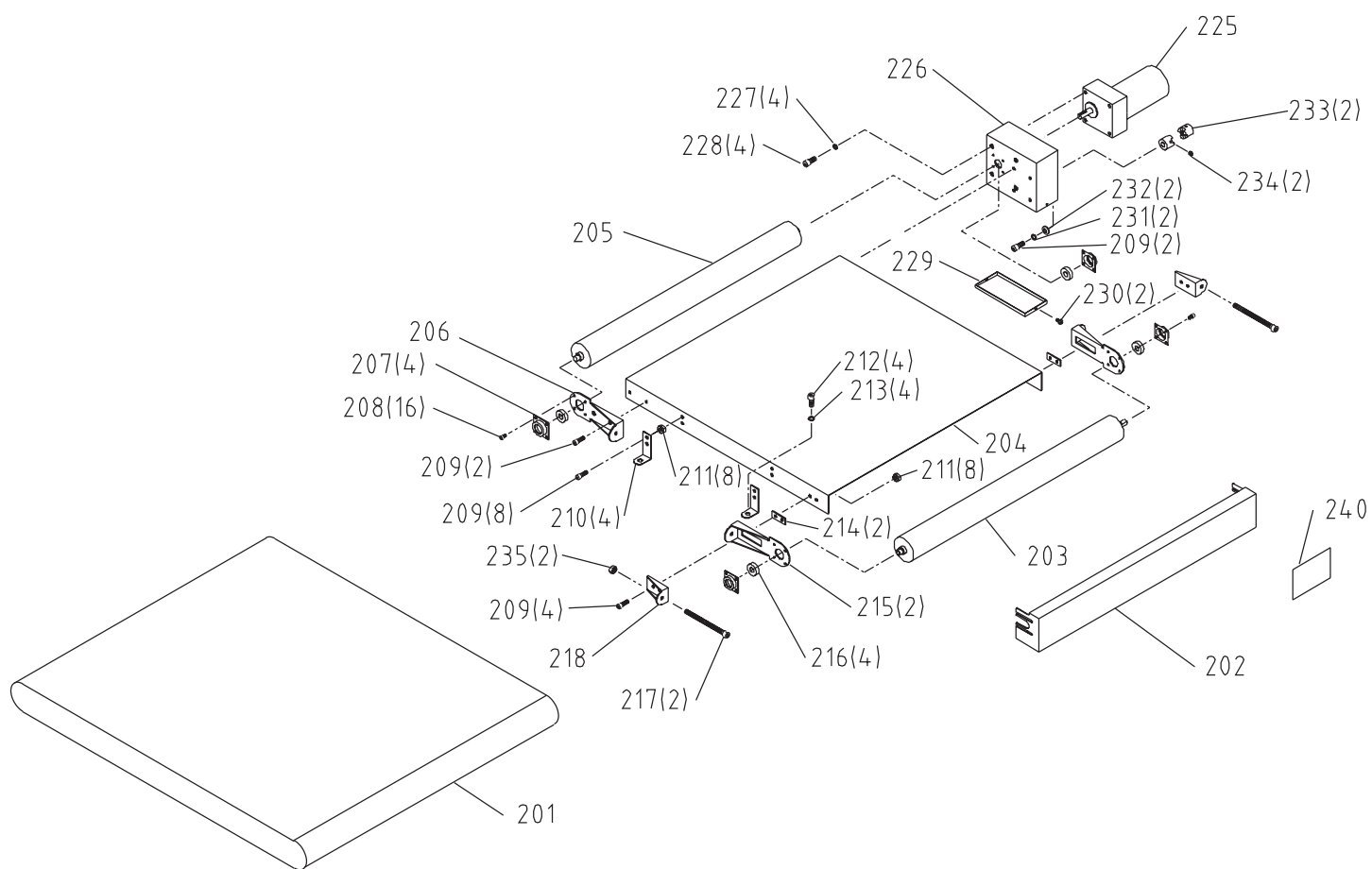


KEY NO.	PART NO.	DESCRIPTION	QTY.	KEY NO.	PART NO.	DESCRIPTION	QTY.
1A	OR70414	Motor	1	13	OR71038	Motor Base	1
1B	OR70362	Motor Spec Plate	1	14	OR71039	Base Shaft	1
1C	OR94105	Capacitor	1	15	OR94076	5/16 Flat Washer	4
2	OR94060	6mm x 6mm x40mm Key	1	16	OR90640	5/16 -18 x3/4 Hex Head Screw	4
3	OR71034	Pulley	1	17	OR71040	Stand Side	2
4	OR94066	1/4"-20 x 3/8 Soc Hd Set Screw	1	18	OR71041	Front/Rear Stand	1
5	OR90640	5/16-18 x 3/4 Hex Head Screw	4	20	OR90625	5/16 Flat Washer	4
6	OR90625	5/16 Flat Washer	4	21	OR91658	5/16 Lock Washer	4
7	OR71035	Motor Adjustment Plate	1	22	OR90616	5/16 - 18 Hex Nut	4
8	OR90616	5/16 -18 Hex Nut	4	23	OR90640	5/16"-18 x 3/4 Hex Head Screw	12
9	OR90625	5/16 Flat Washer	2	24	OR90625	5/16 Flat Washer	24
10	OR71036	Motor Plate Adjusting Screw	2	26	OR91658	5/16 Lock Washer	12
11	OR94067	Retaining Ring	6	27	OR90616	5/16-18 Hex Nut	12
12	OR71037	Positioning Shaft	2				



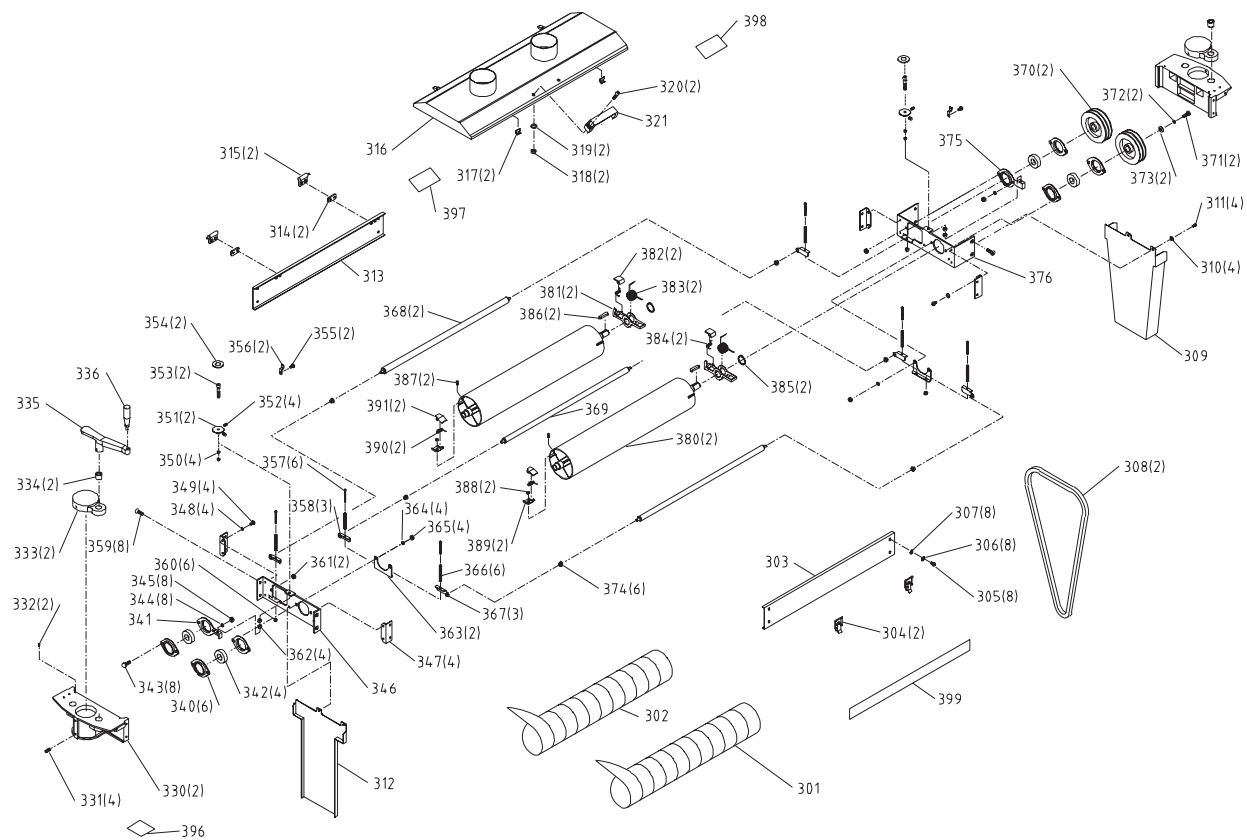
KEY NO.	PART NO.	DESCRIPTION	QTY.
101	OR71042	Cover (Right)	1
102	OR90060	1/4 Flat Washer	4
103	OR90070	1/4 Lock Washer	4
104	OR93848	1/4 - 20 x 3/8 Round Head Screw	4
105	OR71043	Table Support (Front)	1
106	OR71044	Shield Plate	2
107	OR71045	Movable Shield Plate	2
108	OR71046	Bottom Shield Plate (Front)	1
109	OR94068	1/4 - 20 Nylok	4
110	OR90071	1/4 - 20 Hex Nut	8
111	OR70484	Nameplate	1
112	OR93823	Rivet	4
113	OR71047	Front Cover	1
114	OR91658	5/16 Lock Washer	8
115	OR93868	5/16 - 18 x 1/2 Hex Socket Head Cap Screw	8
116	OR71048	Cover (Left)	1
117	OR71049	Table Support (Rear)	1
118	OR71050	Bottom Shield Plate (Rear)	1
119	OR71051	Rear Cover	1
120	OR91668	1/4 - 20 x 3/4 Hex Head Screw	4
121	OR90060	1/4 Flat Washer	24
122	OR94068	1/4 - 20 Nylok Nut	4
123	OR90070	1/4 Lock Washer	4
125	OR94068	1/4 - 20 Nylok Nut	4
126	OR91330	1/4"-20 x 1 Hex Head Screw	8
127	OR93868	5/16 - 18 x 1/2 Hex Socket Head Cap Screw	8
128	OR91658	5/16 Lock Washer	8

KEY NO.	PART NO.	DESCRIPTION	QTY.
130	OR70303	Spec Plate	1
131	OR71052	Safety Rules Label	1
132	OR71053	Scale	1
133	OR94071	10 - 24 x 3/4 Flat Head Screw	1
134	OR71054	Cursor	1
135	OR71055	Spacer	1
140	OR71056	Bevel Gear	4
141	OR94072	1/4 - 20 x 1/4 Soc Head Set Screw	4
142	OR94073	1/4 - 20 x 2 1/2 Hex Head Screw	4
143	OR94074	Soc Head Set Screw	12
144	OR71057	Bushing	2
145	OR94075	1/4 - 20 x 1/4 Soc Head Set Screw	4
146	OR71058	Positioning Collar	2
147	OR71059	Lower Column Bracket	2
148	OR71060	Transmission Shaft	1
149	OR71061	Shaft Mount	2
151	OR71062	Bronze Collar	2
152	OR94077	Bearing (51102)	2
153	OR71063	Screw Shaft	2
154	OR71064	Column	2
155	OR71065	Slide	2
156	OR71066	Screw Bushing	2
157	OR94078	Retaining Ring	4
158	OR90640	5/16 - 18 x 3/4 Hex Head Screw	4
159	OR91658	5/16 Flat Washer	8
161	OR91658	5/16 Spring Washer	4
162	OR90616	5/16 - 18 Hex Nut	4

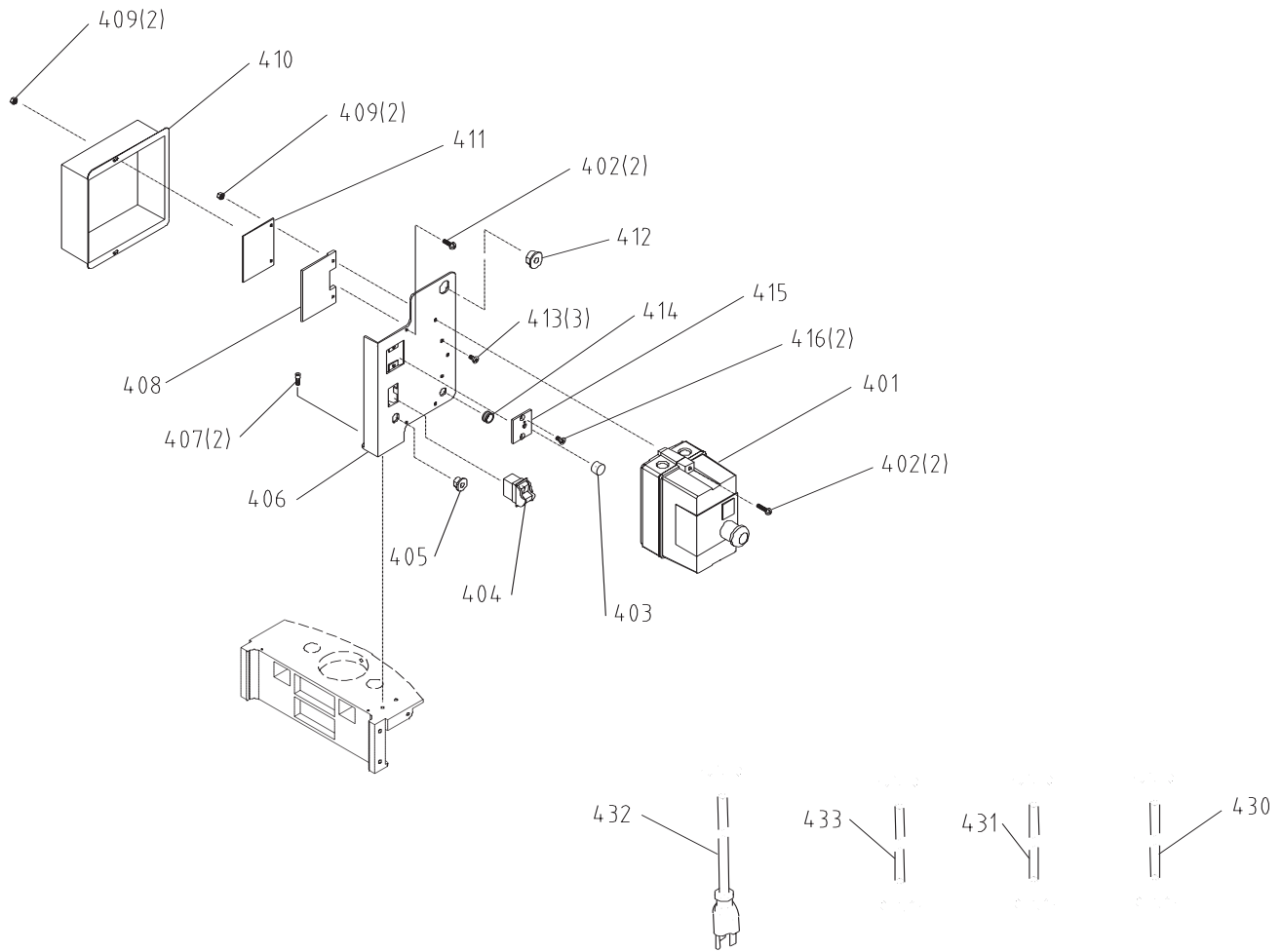


KEY NO.	PART NO.	DESCRIPTION	QTY.	KEY NO.	PART NO.	DESCRIPTION	QTY.
201	OR71067	Conveyor Belt	1	216	OR94081	Bearing (6202)	4
202	OR71068	Table Guard	1	217	OR94082	5/16 -18 x 4 Hex Socket Head Screw	2
203	OR71069	Conveyor Belt Drum	1	218	OR71077	Micro Adjustment Block	2
204	OR71070	Conveyor Belt Platen	1	225	OR70415	Speed Reduction Motor	1
205	OR71071	Conveyor Belt Transmission Shaft	1	226	OR71078	Control Box	1
206	OR71072	Positioning Plate	1	227	OR90070	1/4 Lock Washer	4
207	OR71073	Bearing Cap 6202	4	228	OR91758	M6 x 16 Hex Socket Head Cap Screw	4
208	OR90062	10 - 24 x 1/4 Pan Head Screw	16	229	OR71079	Control Box Bottom Cover	1
209	OR94079	1/4 -20 x 3/4 Hex Socket Head Cap Screw	16	230	OR90691	10 -24 x 3/8 Pan Head Screw	2
210	OR71074	Table Bracket	4	231	OR90070	1/4 Lock Washer	2
211	OR94068	1/4 - 20 Nylok Nut	16	232	OR90060	1/4 Flat Washer	2
212	OR93868	5/16 -18 x 1/2 Hex Socket Head Cap Screw	4	233	OR71080	Shaft Coupler	2
213	OR91658	5/16 Lock Washer	4	234	OR94072	1/4 - 20 x 1/4 Soc Head Set Screw	2
214	OR71075	Pad	2	235	OR90616	5/16 - 18 Hex Nut	2
215	OR71076	Micro Adjustment Positioning Plate	2	240	OR71081	Table Guard Warning Label	1





KEY NO.	PART NO.	DESCRIPTION	QTY.	KEY NO.	PART NO.	DESCRIPTION	QTY.
301	OR71082	Sanding Belt P80 5 1/8"x92-1/2"L	1	353	OR71105	Micro-Adjusting Screw	2
302	OR71083	Sanding Belt P120 5 1/8"x92-1/2"L	1	354	OR94090	Washer	2
303	OR71084	Guard Plate	1	355	OR94091	Screw	2
304	OR71085	Latch	2	356	OR71106	Pointer	2
305	OR93848	1/4-20 x 3/8 Pan Head Screw	8	357	OR94092	M5 x 50 Pan Head Screw	6
306	OR90070	1/4 Lock Washer	8	358	OR71107	Right Pressure Plate	3
307	OR90060	1/4 Flat Washer	8	359	OR94093	5/16 - 18 x 1 Flat Head Screw	8
308	OR94084	V Belt (17-650C)	2	360	OR93933	M5 Nylok Nut	6
309	OR71086	Pulley Guard	1	361	OR94049	5/16 - 18 Nylok Nut	2
310	OR90060	1/4 Flat Washer	4	362	OR90616	5/16 - 18 Hex Nut	4
311	OR91668	1/4 - 20 x 3/4 Hex Head Screw	4	363	OR71108	Pressure Plate Bracket	2
312	OR71087	Column Guard	1	364	OR91658	5/16 Lock Washer	4
313	OR71088	Dust Hood Mounting Plate	1	365	OR90616	5/16 - 18 Hex Nut	4
314	OR71089	Hinge Pad	2	366	OR94095	Spring	6
315	OR71090	Cover Hinge	2	367	OR71109	Left Pressure Plate	3
316	OR71091	Dust Hood	1	368	OR71110	Pressure Shaft	2
317	OR71092	Clip	2	369	OR71111	Shaft	2
318	OR90616	5/16 - 18 Hex Nut	2	370	OR71112	Pulley	2
319	OR91658	5/16 Lock Washer	2	371	OR94069	5/16 - 18 x 1 Left Hand Hex Head Screw	2
320	OR90466	5/16 - 18 x 3/4 Hex. Socket Head Cap Screw	2	372	OR91658	5/16 Lock Washer	2
321	OR71093	Dust Hood Handle	1	373	OR90467	3/8 Flat Washer	2
330	OR71094	Upper Column Bracket	2	374	OR90381	M5 Hex Nut	6
331	OR94085	Soc Head Set Screw	4	375	OR71113	Right Micro-Adjusting Bearing Cap	1
332	OR71095	Bumper	2	376	OR71114	Right Bearing Housing	1
333	OR71096	Column Cover	2	380	OR71115	Drum	2
334	OR71097	Collar Cap	2	381	OR71116	Pull Clamp Bracket	2
335	OR71098	Handle	1	382	OR71117	Pull Clamp	2
336	OR71099	Handle Knob	1	383	OR71118	Pull Clamp Drum Spring	2
340	OR71100	Bearing Cap	6	384	OR71119	Pull Clamp Clip Spring	2
341	OR71101	Left Micro-Adjusting Bearing Cap	1	385	OR94097	Retaining Ring	2
342	OR94086	Bearing	4	386	OR94060	6mm x 6mm x 40mm Key	2
343	OR94087	5/16 - 18 x 1 Carriage Bolt	8	387	OR94098	10 - 24 x 3/8 Flat Head Screw	2
344	OR91658	5/16 Lock Washer	8	388	OR90374	10 - 24 Hex Nut	2
345	OR90616	5/16 - 18 Hex Nut	4	389	OR71120	Fixed Clamp Bracket	2
346	OR71102	Left Bearing Housing	1	390	OR71121	Fixed Clamp Spring	2
347	OR71103	Angle Plate	4	391	OR71122	Fixed Clamp	2
348	OR90070	1/4 Lock Washer	4	396	OR71123	Rotation Instruction Label	1
349	OR93848	1/4 - 20 x 3/8 Pan Head Screw	4	397	OR71124	Dust Hood Warning Label	1
350	OR94088	Nut	4	398	OR71125	Dust Hood Warning Label	1
351	OR71104	Bushing	2	399	OR71126	Warning Label ( Zebra Pattern)	1
352	OR94089	Set Screw	4				



KEY NO.	PART NO.	DESCRIPTION	QTY.
402	OR94099	10 - 24 x 3/4 Pan Head Screw	4
403	OR71128	Knob	1
404	OR71129	Switch (Conveyor)	1
405	OR94106	Strain Relief	1
406	OR71130	Switch Mounting Plate	1
407	OR91668	1/4 - 20 x 3/4 Hex Head Screw	2
408	OR71131	PC Board Plate	1
409	OR90374	Nut 3/16"-24UNC	4
410	OR71132	Switch Box	1
411	OR71133	PC Board	1
412	OR94100	Strain Relief (6R-3)	1
413	OR94107	Screw	3
414	OR71134	Cabel Guard	1

KEY NO.	PART NO.	DESCRIPTION	QTY.
415	OR71135	Insulation Board	1
416	OR94101	M5 x 15 Flat Head Screw	2
430	OR71136	Terminal Cord	2
431	OR71137	Switch Cord	2
432	OR71138	Cord	1
433	OR71139	Motor Cord	1
490	OR94102	10/12 Open End Wrench (Not Shown)	1
491	OR94103	6mm T- Handle Wrench (Not Shown)	1
492	OR94104	5mm T-Handle Wrench (Not Shown)	1
501	OR71140	Manual (Not Shown)	1
502	OR71141	Manual French (Not Shown)	1
503	OR71142	Manual Spanish (Not Shown)	1



# **STEEL CITY TOOL WORKS**

**[www.steelcitytoolworks.com](http://www.steelcitytoolworks.com)**

**1-877-SC4-TOOL**  
**(1-877-724-8665)**

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*5 Year Warranty*

